

Work Order ID 86122

Wednesday, June 20, 2012 3:48:25 PM

86122

Page 1

Item ID: D3174-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mounting Lug
 Start Date: 6/21/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 7/13/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: umf Date: 12-06-20 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3174	Rev A1

100	0.00
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100

Waterjet

FLOW CNC Waterjet

304.063

FLOW WATER JET

Memo

1-Cut as per Dwg D3174 Dwg Rev: A1 Prog Rev: A1 2-
 Deburr if necessary

0.00

1312-6-21

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

1312-6-21

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

1312

12 06 21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Mounting Lug

Stop ***NS2***

Start Date: 6/21/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 7/13/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr if necessary

140

0.00

140

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

150

0.00

150

Packaging

Identify as per dwg & Stock Location: WA

Memo

0.00

Packaging

*****STOCK IN BASKET CELL*****

12 12.06.21
12 12.06.22

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/6/25 *[Signature]*
MLJ 12/06/22

Picklist Print

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Page 1

Work Order ID: 86122

Parent Item: D3174-1

Parent Item Name: Mounting Lug

Start Date: 6/21/2012

Required Date: 7/13/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: A03.01.29New issueKJ/RF
IPP Rev:B 08-08-19 now made on water jet DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	3.5746	0.0408	0.5153684	2		

1312-6-21

Location

MAT020

121889

Loc Qty

3.574633

3.574633

Loc Code

~~119188~~ 121889

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

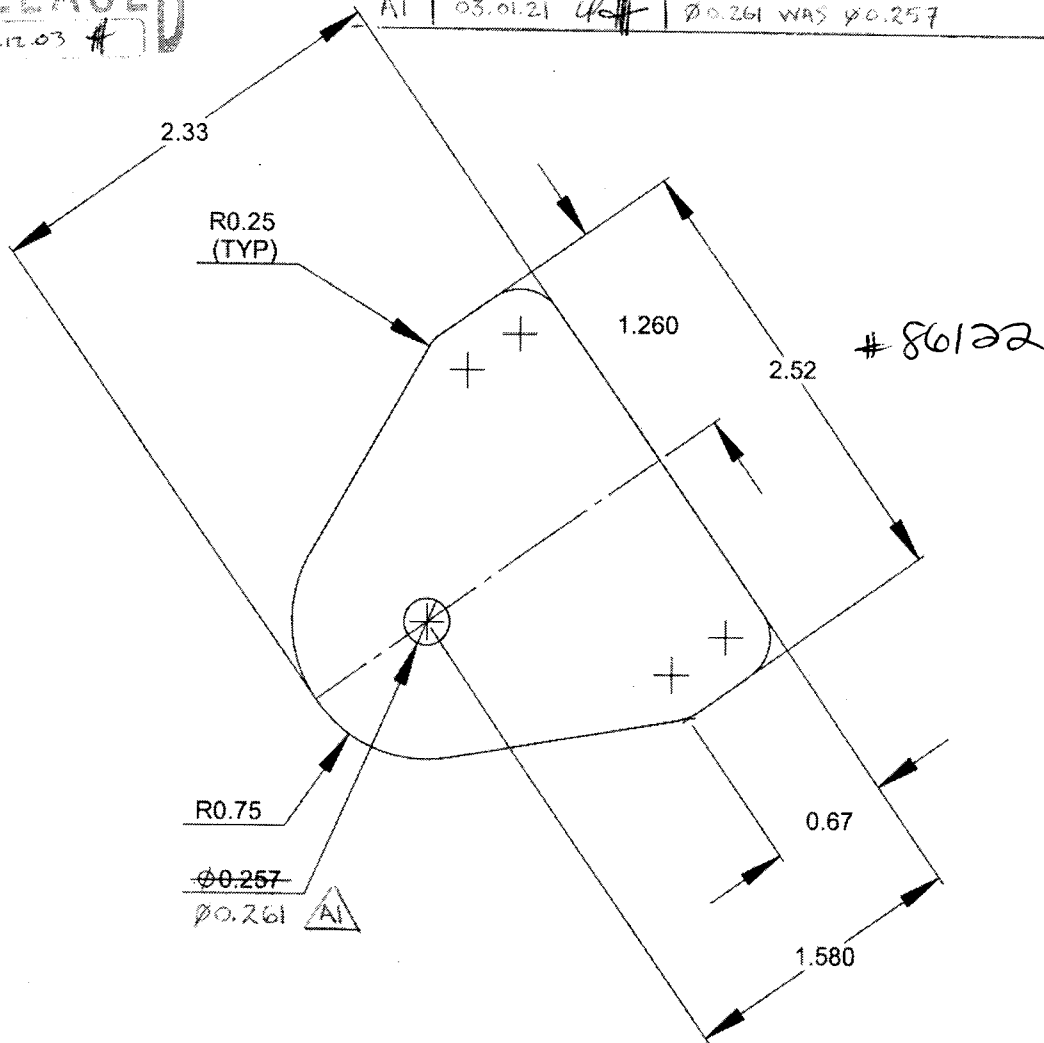
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3174	REV. A SHEET 1 OF 1
DATE 02.12.03	TITLE MOUNTING LUG		SCALE 1:1
A	02.12.03	NEW ISSUE	
AI	03.01.21 <i>UP</i>	Ø0.261 WAS Ø0.257	

RELEASED
02.12.03 #



D3174-1 MOUNTING LUG

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET 0.063 THICK
(REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005-0.010 MAX
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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